

# Work Order ID 110369

December-17-13 9:24:26 AM

\*110369\*

Page 1

Item ID: D130-700-011

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Bearpaw

Stop

\*NS2\*

Start Date: 12/17/13

Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 12/17/13

Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 13-12-18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3167	Rev A1								
100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D130-700-011CHG001								
160	Pick Kit	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 14-01-20

DAS  
31  
9-89

14-01-20

2x

2



DAS  
28  
9-89

2x

14-1-20

DAS  
31  
9-89

14-01-20

2x

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 110369

December-17-13 9:24:26 AM

\*110369\*

Page 2

Item ID: D130-700-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bearpaw

Start Date: 12/17/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
*180*	Packaging					2x	8	14-01-21	
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D130-700-011 Location <del>FG011</del>								
190	QC21- Final Inspection - Work Order Release	0.00							
*190*						MLJ		14-01-22	
QC	Memo	0.00							
Quality Control									

④ 14-01-21

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print .

January-17-14 11:40:27 AM

Page 1

Work Order ID: 110369

Parent Item: D130-700-011

Parent Item Name: Bearpaw

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN412A Bolt		Purchased	No			170	Each	127.0000	4	8			DAS 26 9-89
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Location Loc Qty Loc Code

FG	10	
120423	10	
ST356	117	
M126105	67	
M127817	50	

AN415A Bolt		Purchased	No			170	Each	550.0000	8	16			DAS 26 9-89
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Location Loc Qty Loc Code

GA	100	
120449	100	
st357	450	
m127817	450	

D2132B060 Clamp Cushion		Manufactured	No			170	Each	70.0000	4	8			DAS 26 9-89
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Location Loc Qty Loc Code

FG	15	
93429	15	
ST409	55	
111120	51	
52649	4	

14-1-20.  
B108914.

# Picklist Print

January-17-14 11:40:27 AM

Page 2

Work Order ID: 110369  
Parent Item: D130-700-011  
Parent Item Name: Bearpaw

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 2.00

Required Qty: 2.00

D2274  
Radius Block

Manufactured No

170 Each 727.0000

12 24

DAS 28 9-89

Location	Loc Qty	Loc Code
FG	12	
86855	12	
ST007	8	
65047	8	
ST008	707	
108466	10	
109534	397	
110264	300	

24x

D2519  
Clamp

Manufactured No

170 Each 53.0000

4 8

DAS 28 9-89

Location	Loc Qty	Loc Code
ST456	53	
101510	23	
62078	4	
99606	26	

8x

D2529  
Washer

Manufactured No

170 Each 259.0000

12 24

DAS 28 9-89

Location	Loc Qty	Loc Code
ST011	259	
108881	200	
109580	59	

24x

D3167-1  
Bearpaw

Manufactured No

Each 1.0000

23 4

110296 12/14/17

Location	Loc Qty	Loc Code
ST269	1	
43828	1	

4

January-17-14 11:40:27 AM

Shop Packet Print

Page 2

# Picklist Print

January-17-14 11:40:27 AM

Page 3

Work Order ID: 110369

Parent Item: D130-700-011

Parent Item Name: Bearpaw

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 2.00

Required Qty: 2.00

D3171-1

Manufactured No

170 Each 12.0000

4 8

DAS  
26  
9-89

Angle Bracket

DAS  
31  
9-89

Location

Loc Qty

Loc Code

ST031

12

105590

12

8x

MS2104214

Purchased No

170 Each 4,731.0000

12 24

DAS  
26  
9-89

Locknut

Location

Loc Qty

Loc Code

GA

68

m126333

68

ST509

4000

m127255

2000

m127813

2000

ST518

663

m127376

663

24x

NAS1149D0463J

Purchased No

170 Each 7,432.0000

12 24

DAS  
26  
9-89

WASHER

Location

Loc Qty

Loc Code

ST294

3032

M127693

3032

ST510a

4400

M127813

1400

M127904

3000

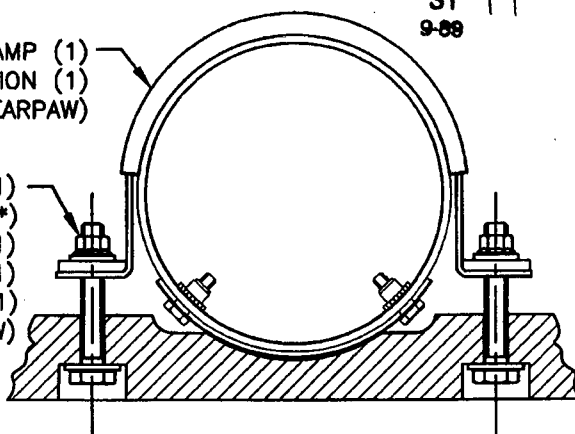
24x

DAS  
31  
9-89

14-01-20

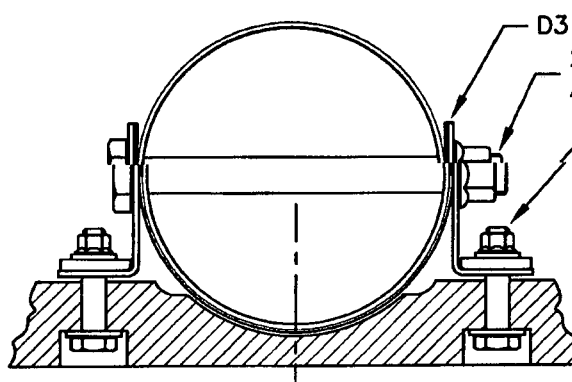
D2519 CLAMP (1)  
D2182B060 RUBBER CUSHION (1)  
(2 PLACES PER BEARPAW)

MS21042L4 NUT (1)  
AN960JD416 WASHER (1\*)  
D2274 RADIUS BLOCK (1)  
D2529 WASHER (1)  
AN4-15A BOLT (1)  
(4 PLACES PER BEARPAW)



\*See note 6

Figure 3 - Clamping Detail (Forward Clamps)



\*See note 6

Figure 4 - Clamping Detail (Aft Clamps)

D3171-1 ANGLE (1)  
22201BC060090L SCREW (1) (REF)  
ASN52320BH120N NUT (1) (REF)

AN4-12A BOLT (1)  
D2529 WASHER (1)  
D2274 RADIUS BLOCK (1)  
AN960JD416 WASHER (1\*)  
MS21042L4 NUT (1)  
(2 PLACES PER BEARPAW)

## 5. PARTS LIST

Qty	Part Number	Description
X	D130-700-011	BEARPAW INSTALLATION
4	D2182B060	Rubber Cushion
12	D2274	Radius Block
12	D2529	Washer
4	D2519	Clamp
2	D3167-1	Bearpaw
4	D3171-1	Angle
4	AN4-12A	Bolt
8	AN4-15A	Bolt
12	AN960JD416	Washer
12	MS21042L4	Nut (or MS21042-4)

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Revision: A  
Date: 02.10.08